

Date: Monday, 7/9/2007 11:47:32 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CAP		
Job Number	: 33374		Part Number	: D32851		
Estimate Number	: 11173		Drawing Number	: D3285 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 7/9/2007 S.O. No. : N/A		Drawing Revision	: A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 7/16/2007 Qty: 30 Um: Each		
Previous Run	: 30293					
Written By	: <u>JL</u>					
Checked & Approved By	: <u>JL 07.07.09</u>					
Comment	: Est. A 04.07.14 New issue KJ/JLM					
	: Est Rev:B Now on Waterjet 07-03-06 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 0.1603 sf(s)/Unit Total : 4.8101 sf(s) 6061-T6 .080 Sheet Material: 6061-T6 (QQ-A-250/11) 0.080" thick or 5052-H32 (QQ-A-250/8) 0.080" thick (M6061T6S.080 or M5052H32S.080) <u>HB 07-07-17</u> Identify for D3285-1 Batch: <u>M104921</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3285 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> <u>HB 07-07-17</u>	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>HB 07-07-17</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<u>HB 07-07-17</u> <u>(X 30)</u> <u>Counted 30</u>	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/07/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: CAP
Job Number: 33374		Part Number: D32851
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<i>HJ 07-07-19 30</i>
6.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>2/2/1981</i>
7.0	PACKAGING 1 	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		<i>7/7/1989</i>
8.0	QC21 	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		<i>07.07.20 HJ</i>
Job Completion 		<i>U 07.07.20</i>
<i>Bonny</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>33374</b>
<b>Description:</b> Cap	<b>Part Number:</b>	<b>D3285-1</b>
<b>Inspection Dwg:</b> D3285 <b>Rev:</b> A		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>BS</u>	Audited by: <u>SP</u>	Prototype Approval:	N/A
Date: <u>07-07-17</u>	Date: <u>07/07/18</u>		Date: N/A

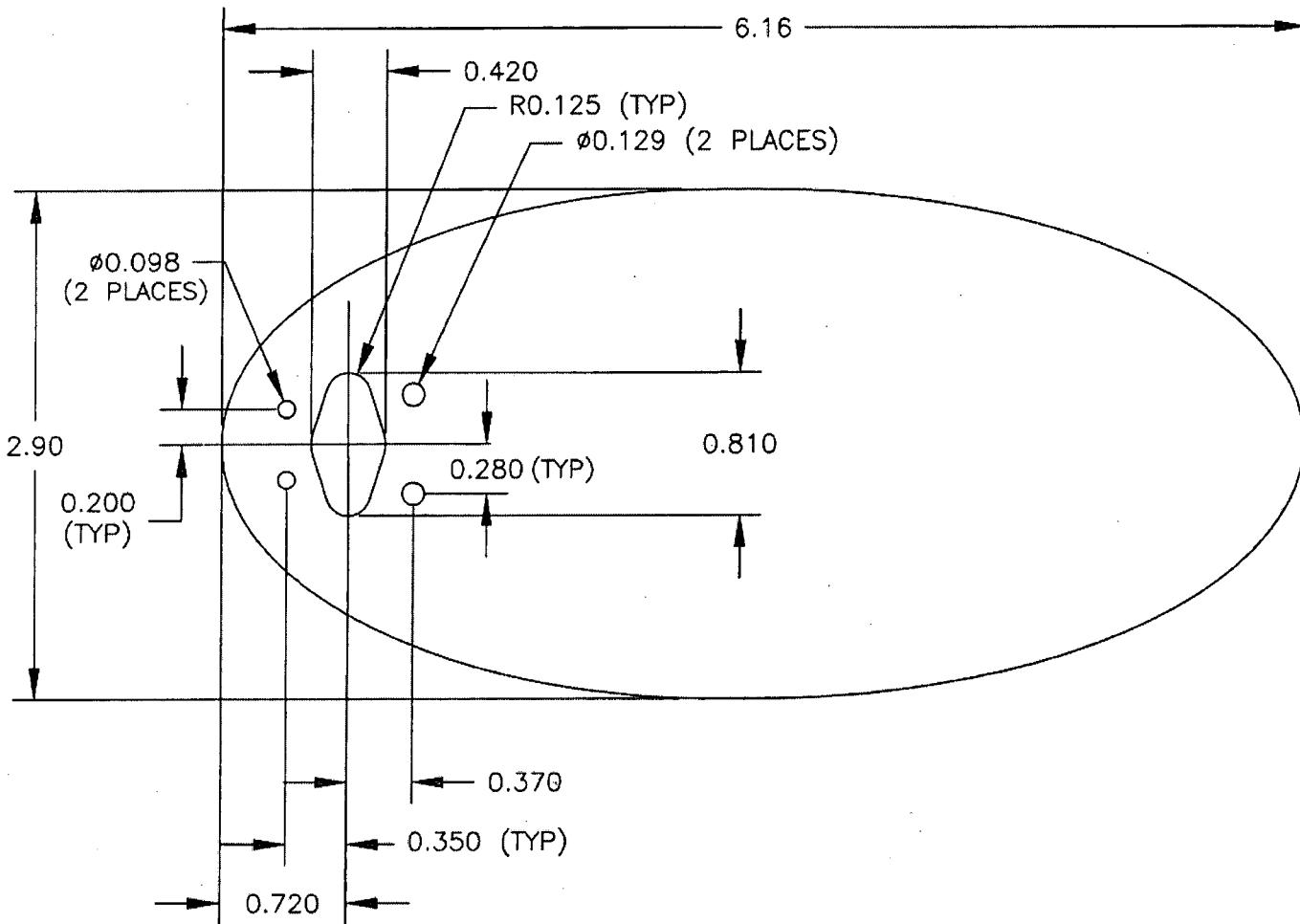
Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	<i>[Signature]</i>



ACOPY  
ORIG

DESIGN	DP	DRAWN BY	DP	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	HP	APPROVED	HP	DRAWING NO. D3285
DATE	04.05.08			REV. A SHEET 1 OF 1
				SCALE 1:1
A	04.05.08	NEW ISSUE		

RELEASED  
04.06.08



### D3285-1 CAP

1) MATERIAL: 6061-T6 (QQ-A-250/11) OR

5052-H32 (QQ-A-250/8) 0.080 THICK

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

2) ACID ETCH, ALODINE PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

WORK ORDER

33374